

Work Order ID 165477

Wednesday, August 23, 2017 3:35:21 PM

165477

Page 1

Item ID: D3916-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Light Rib
Start Date: 8/23/2017 Start Qty: 9.00 ***Q*** Cust Item ID:
Required Date: 8/25/2017 Req'd Qty: 9.00 ***Q*** Customer:
Reference:

Approvals: Process Plan: UM ^{DAS} 21 Date: AUG 23 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ ⁹⁻⁸⁹ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3916	A								
100		0.00							
100									
Large Fab	Memo	3.06							
Large Fab	1- Cut tube 50" 2- Bend tube with manuel pipe bender as per DT9566 *** Make line at 9.00" annd use jig for other line*** 3- Trim access tube material to finish size as per dwg D3916								
110	QC6- All purchased or subcontracted products	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>WACOY</u>	0.00							
120									
Packaging	Memo	0.09							
Packaging	LOCATION: WA004								

9x D.M.L 2017-8-24^{DAS}
38
⁹⁻⁸⁹9
AUG 25 20179x DC 2017-08-25

Work Order ID 165477

Wednesday, August 23, 2017 3:35:21 PM

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Item ID: D3916-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Light Rib

Start Date: 8/23/2017 Start Qty: 9.00

9

Cust Item ID:

Required Date: 8/25/2017 Req'd Qty: 9.00

9

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.90

Quality Control

176/520

DAS
21
9-89

W

AUG 25 2017

Picklist Print

Wednesday, August 23, 2017 3:35:20 PM

Page 1

Work Order ID: 165477

165477

Parent Item: D3916-5

D3916-5

Parent Item Name: Light Rib

Start Date: 8/23/2017

Required Date: 8/25/2017

Start Qty: 9.00

Required Qty: 9.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
as per dwg revA 10.03.15 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.500W.049		Purchased		No		100	f	659.3468	4.166	39.46737			

M304TS0 500W 049

D.M.L 2017-8-25

Square Tubing

Location

Loc Qty

Loc Code

WA004

659.34684

138186

40

M136011

4.64684

M137257

30.5

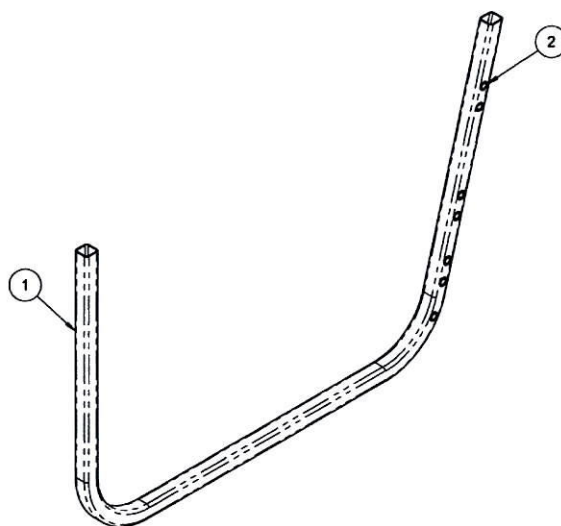
M137992

24.2

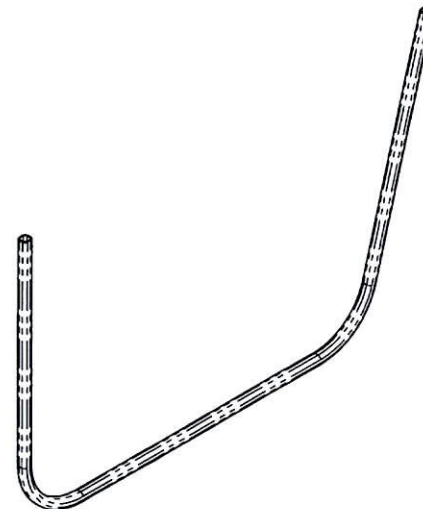
M138186

600

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

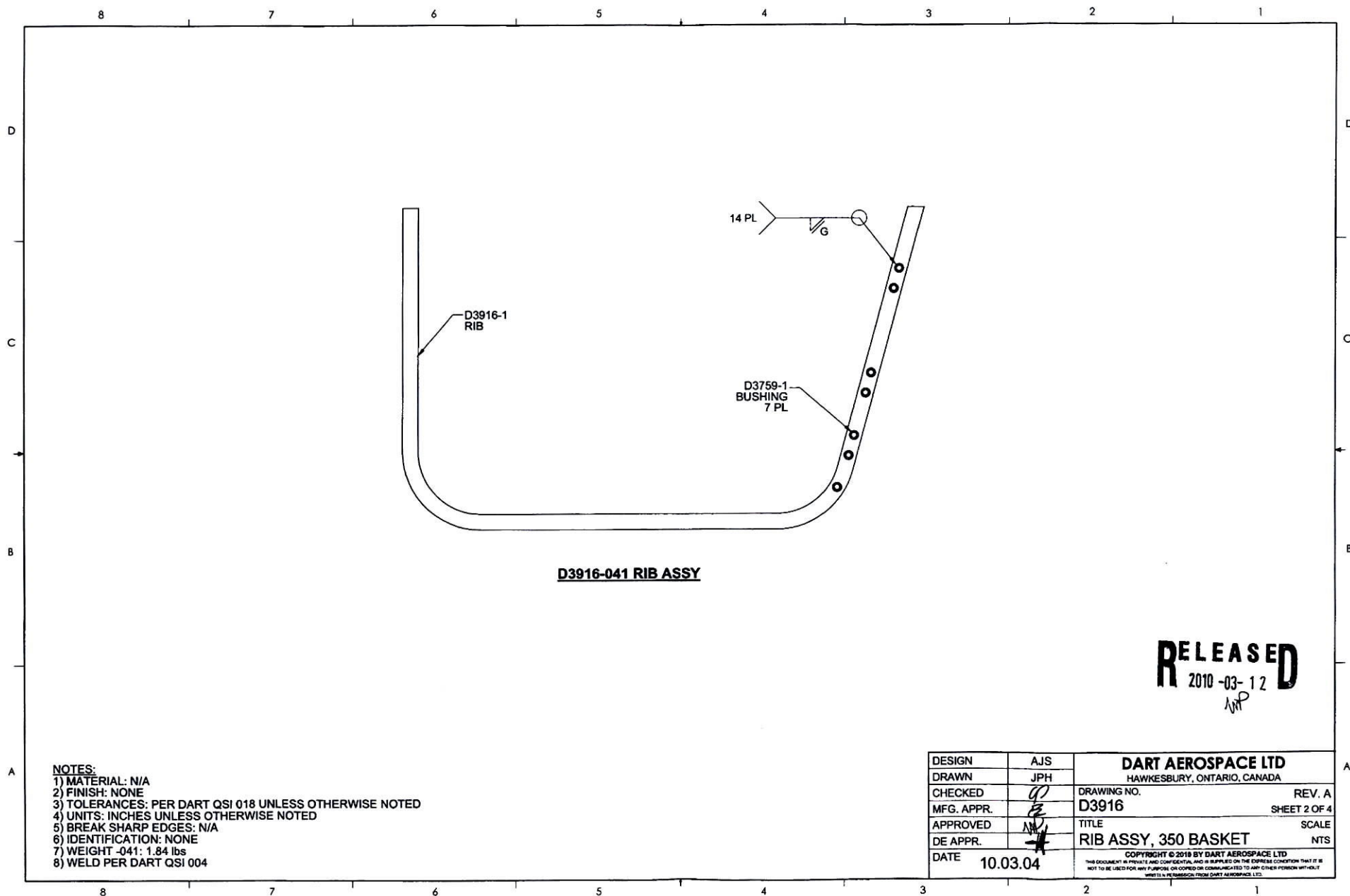
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165477

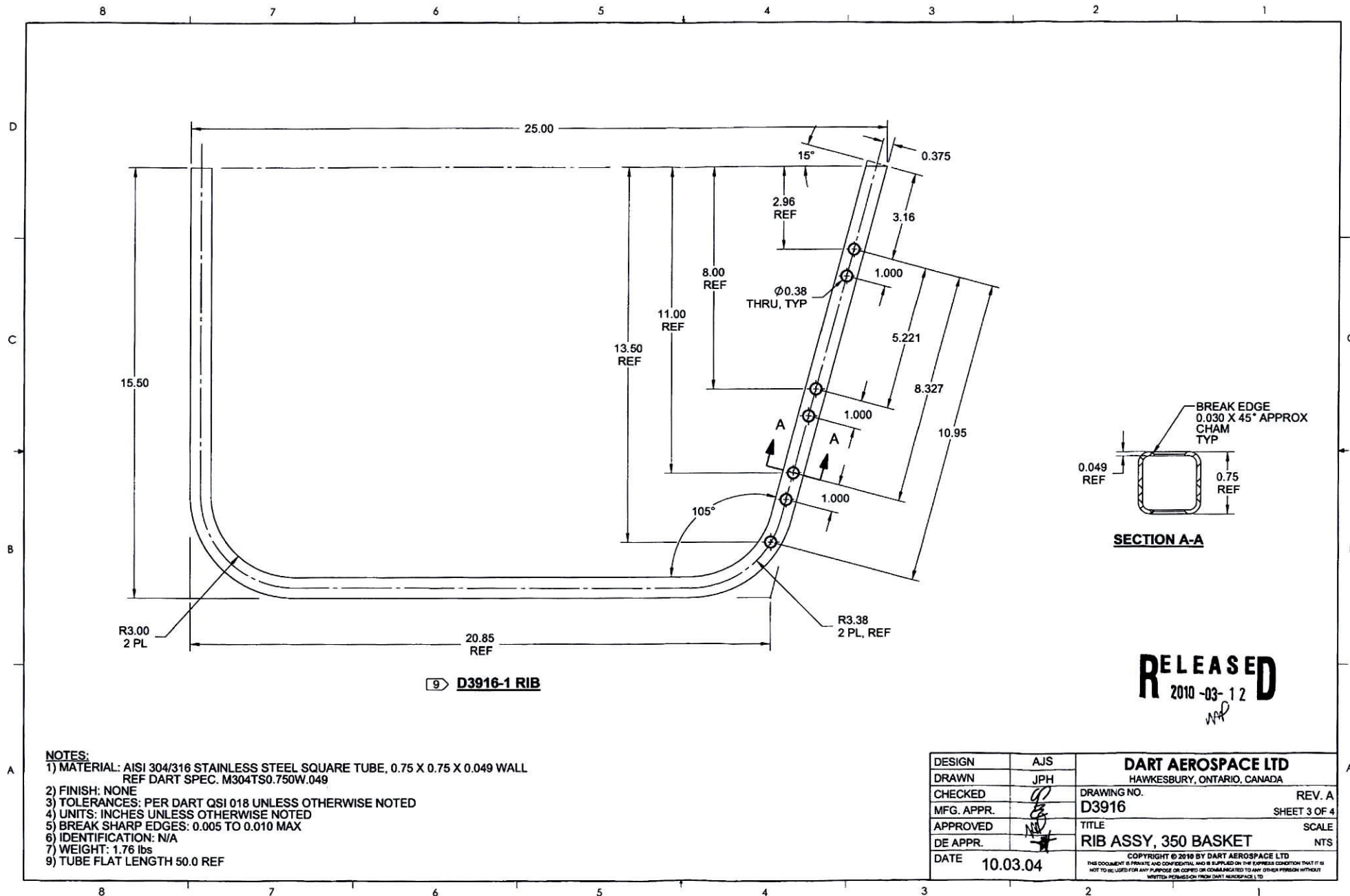
LM

AUG 23 2017

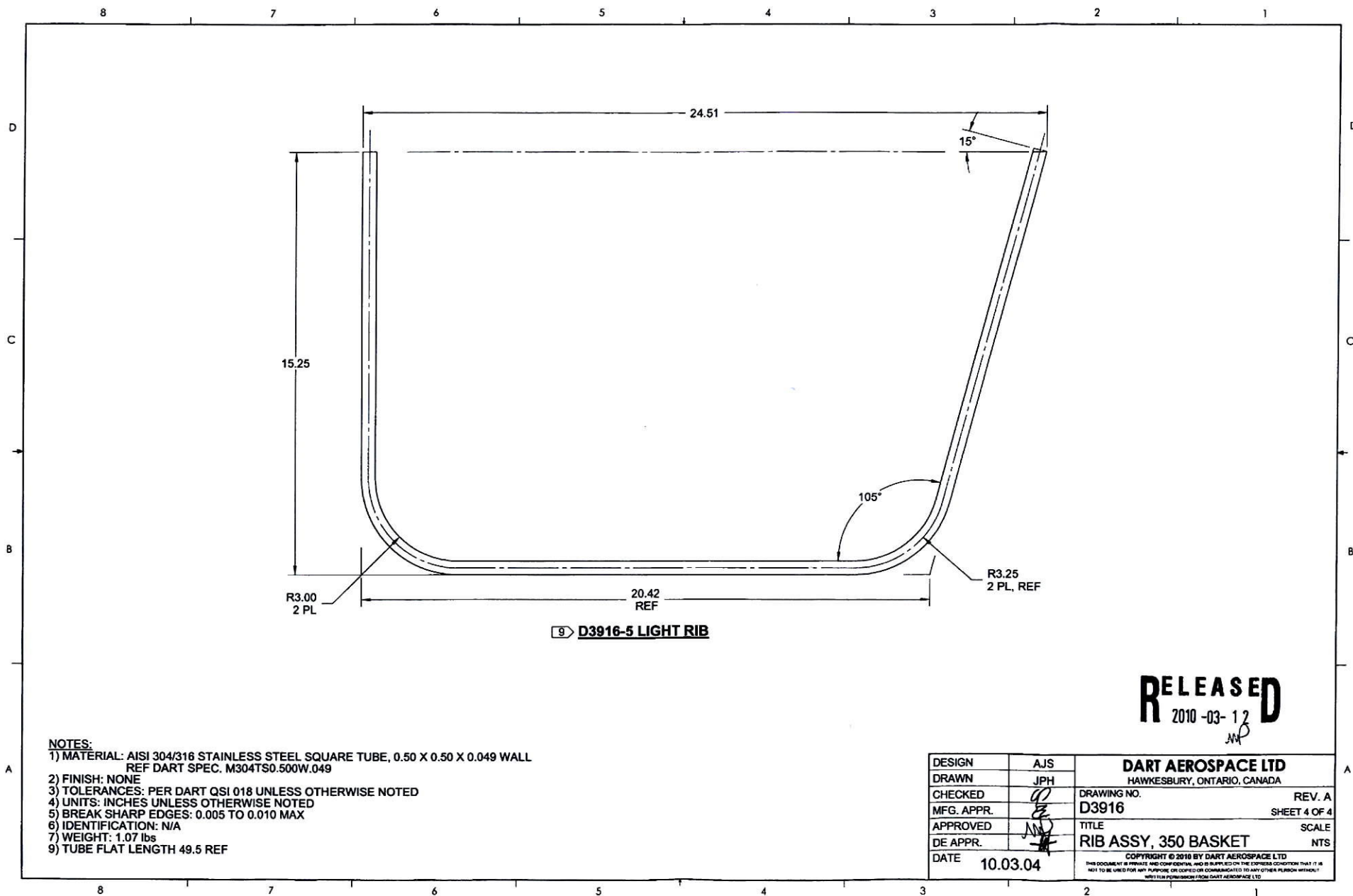
OK 10.12.21
UNDER REVIEW
10.10.11
ADDITION OF HOLE + BUSHING
ON D3916-041 RIBS.
RELEASED
2010-03-12
JMP

A	NEW ISSUE	DESCRIPTION	JPH	10.03.04
REV.			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED	[Signature]	DRAWING NO.	REV. A	
MFG. APPR.	[Signature]	D3916	SHEET 1 OF 4	
APPROVED	[Signature]	TITLE	SCALE	
DE APPR.	[Signature]	RIB ASSY, 350 BASKET	NTS	
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		





RELEASED
 2010-03-12
[Signature]



RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

Purchase Order Receipt Listing

Monday, July 31, 2017 3:13:40 PM

Page 1 of 1

All amounts are calculated in domestic currency.

All Vendors PO ID PO35151 Receipt Dates from 7/28/2017 to 7/28/2017 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VU-EAG001	Eagle Stainless	DAS							
<u>PO35151</u>	3		<u>M304TS0.500W.049</u>	f	8/16/2017	7/28/2017	600.0000 ✓		0.0000	0	\$0.00
USD	No		Square Tubing	f	600.0000	PLOU01			0.0000	0	
			<u>m138186</u>								

Total Received Quantity: 600.0000
Total Qty to Inspect (PO U/M): 0.0000
Total Reject Quantity: 0.0000
Total Receipt Value:
Total Balance Due Quantity: 0.0000



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

OUTSTANDING PO REPRINT

Purchase Order ID PO35151

Purchase Order Date 1/31/2017

PO Print Date 7/31/2017

Page Number 1 of 1

Order From : VU-EAG001
EAGLE STAINLESS
10 DISCOVERY WAY
FRANKLIN, MA
US

Ship To : DART AEROSPACE LTD
1270
ABERD
EEN
HAWKE
SBURY,
ON
K6A
1K7
CANAD
A

Contact Name
Vendor Phone 800 528 8650 Ext.800 520 1954
Vendor Fax 800 520 1954
Ship To Contact
Ship To Phone

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB Destination-Collect

Ship Method
Ship Acct

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
3	<u>M304TS0.500W.049</u>	Square Tubing	8/16/2017 Yes 8/16/2017	600.00 f	\$3,930.00
MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING AS PER ASTM A554 MILL. FINISH OR ASTM A269 MILL. FINISH					
Line Total:					\$3,930.00
4	M304TS0.500W.049	Square Tubing	9/20/2017 Yes 9/20/2017	600.00 f	\$3,930.00
MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING AS PER ASTM A554 MILL. FINISH OR ASTM A269 MILL. FINISH					
Line Total:					\$3,930.00
Outstanding PO Total:					\$7,860.00

PO Instructions: DELIVERY DATE TBD
QUOTE NO 974235

CS

Terms & Condition of
Purchasing(Suppliers) and
Procurement Quality Clauses are an
integral part of our AS9100

Change Nbr: 6

Change Date: 7/31/2017



EAGLE STAINLESS

Tube and Fabrication, Inc. 10 Discovery Way Franklin Industrial Park Franklin MA 02038

Tel: 800-528-8650, 508-528-8650 Fax: 800-520-1954, 508-520-1954 Email: eagle@eagletube.com Web: www.eagletube.com

Packing List

Bill Dart Aerospace, Ltd
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace, Ltd
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

PO Number: PO35151

Shipment No: 132392
Shipment Date: 07/21/17
Order Number: 136891
Order Date: 02/08/17

Customer Code: 000000001912
Phone: (613) 632-5200
Terms: Net 30 Days

Ship Via: FedXFrCol#94011728

Quantity				Unit	Description	Job Number
Open	Shipped	Back Ord	Canceled			
1,202	600	602		FT	1912-SQ0500049T304 T304 SmIs Square Tubing .500" x .500" x .049" Wall x (240) - 117"±.500"/-000 Lengths.) As Drawn Temper. Chem to ASTM A269. Certs Required. Pack to Protect. NOT an Aerospace Application... NOT Defars Material - Chantal Lavoie 12/02/15.)	136891-01

150-3-31



EAGLE STAINLESS

Tube and Fabrication, Inc

Franklin Industrial Park 10 Discovery Way Franklin, MA 02038

Telephone: (508) 528-8650 or (800) 528-8650 Fax: (508) 520-1954 or (800) 520-1954 Website: www.eagletube.com Email: info@eagletube.com

MATERIAL TEST REPORT CERTIFICATE OF CONFORMANCE

SOLD TO: Dart Aerospace, Ltd.
ADDRESS: 1270 Aberdeen Street
Hawkesbury ON K6A 1K7
DATE: 7/21/2017
PURCHASE ORDER: PQ35151
OUR ORDER#: 136891
PART #: NA
REVISION: NA

HEAT #: 624005
SOURCE: 50-55504-03-17
ITEM: 500 X .500 SQUARE TUBING X .049 WALL T304/304L SMLS
Spec: ASTM A269-15a/A213-15c CHEMISTRY ONLY
Temper: AS DRAWN TEMPER
Quantity: 600 **Units:** FT

C: .006	Ti: -	Passivation Per ASTM A967: -
Si: .462	Cb: -	Yield (PSI): -
Mn: 1.109	Ta: -	Tensile (PSI): -
P: .030	Fe: balance	Elong. (% IN 2"): -
S: .004	Cu: .35	Hardness (Rockwell): -
Ni: 8.94	Al: -	Flattening: -
Cr: 18.30	N: .032	Flaring: -
Mo: .314	Co: .149	Rev F/B: -
Misc Chem: -		Flange: -
Misc Chem: -		Int C/E: -
Misc Chem: -		Eddy Current: -
		Hydrostatic: -
		Grain Size: -

Notes: MELT: FRANCE
Notes: MFG: USA
Notes: MERCURY FREE
Comments:

Conforms to all drawing and/or specification requirements. To the best of our knowledge the material is mercury free, and compliant with Directive 2011/65/EC and 2006/122/ECOF regarding the Restriction of Hazardous Substances (RoHS) and is conflict free per Dodd-Frank section 1502. Reports governing this material are on file.

Paulette Cartier

EAGLE STAINLESS TUBE AND FABRICATION INC.
Paulette Cartier
Quality Assurance Manager

DMG
Int.

7/21/2017
Date

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M304750,500 W.049

PO / BATCH NO.: 0935151/138186

DATE: AUG 01 2017

MATERIAL CERT REC'D: yes

THICKNESS ORDERED: W.049

QUANTITY RECEIVED: 704'

THICKNESS RECEIVED: W.049

QUANTITY INSPECTED: 704'

SHEET SIZE ORDERED: N/A

QUANTITY REJECTED: 0

SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	☒	
CORRECT FINISH	☒	N	
CORROSION	Y	☒	
CORRECT GRAIN DIRECTION	☒	N	
CORRECT MATERIAL PER M-DRAWING	☒	N	<u>ASTM A269</u>
CORRECT THICKNESS	☒	N	
PHOTO REQUIRED	Y	☒	
CORRECT REF # TO LINK CERT	☒	N	<u>HT # 136891</u>
CORRECT MATERIAL IDENTIFICATION	☒	N	
CORRECT M# ON THE MATERIAL	☒	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	☒	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)
INSPECTED BY: _____	DAS <u>5</u>	SIGNED OFF BY: _____
DATE: <u>AUG 01 2017</u>	0-89	DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

PURCHASE MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBING

FINISH: ~~ASTM A554 MILL FINISH~~ **DAS**
 OR ASTM A269 MILL FINISH **5**

WHERE: A.AAA = WIDTH IN INCHES
 .TTT = WALL THICKNESS IN INCHES

PART NUMBER: M304TS | A.AAA | W | .TTT
 | WIDTH | WALL

PART NUMBER: EG. 0.75" X 0.75" X 0.049 WALL = M304TS0.750W.049

RELEASED
 2014-05-26

D	"SEAMLESS" REMOVED FROM PURCHASE MATERIAL SPECIFICATION (SEE NCR14-3818)	DS	14.05.20
C	"SEAMLESS" ADDED TO PURCHASE MATERIAL. ASTM A269 ADDED TO FINISH. REASON: SPEC ADDED FOR 1/2" TUBING	AJS	09.10.15
B	DRAWING MOVED TO "B" SIZE BORDER. FINISH ADDED (SEE NCR 08-046 FOR DETAILS).	AJS	08.08.28
A	NEW ISSUE	DS	01.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	M304TS	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	304/316 SQUARE TUBING	NONE
DATE	14.05.20	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR IN ANY MANNER THAT COULD BE DETRIMENTAL TO THE NATIONAL DEFENSE.	